

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020765**Date Inspected:** 20-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

West Grillage:

ZPMC personnel performing Ultrasonic Testing of weld joint nos: SA712C-265 and 259, complete joint penetration (CJP) weld, after repair welding. ZPMC Quality Control (QC) was identified as Jen Jei Wei. See attached photo for further information.

OBG Seg 13AW:

The Submerged Arc Welding (SAW) process on weld joint no: Seg3013-006 [Deck Panel (DP) 3122A to DP3123A, CJP weld]. The welder is identified as 045265 and was observed welding in the 1G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Repair welding of weld joint no: Seg3013AH-028 [I-rib on K-Plate (KP) 3014A to Floor Beam (FB) 3192A at Panel Point (PP) 119+1500, CJP weld]. The welder is identified as 066261 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS:

345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Critical Welding repair Report (CWR): 2802 Rev-1.

Saddle Support Sub Assembly (West Line):

The SMAW process on weld joint no: SA7513-005 (of Saddle Support Sub-Assembly), CJP weld). The welder is identified as 066674 and was observed welding in 1G position. ZPMC QC was identified as Jen Jie Wei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2211-B-U3b.

The SMAW process on weld joint no: SA7514-005 (of Saddle Support Sub-Assembly), CJP weld). The welder is identified as 067588 and was observed welding in 1G position. ZPMC QC was identified as Jen Jie Wei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2211-B-U3b.

Anchor Blocks (West):

This QA Inspector observed ZPMC personnel performing Wet Magnetic particle Testing on Anchor Blocks (for West line). See attached photo for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer